Thermal Epoxy Procedure
STYCASC™ 2850 FT BLACK

1. Health and Safety -- Keep the general Safety Rules; no inhalation, no direct touch on your skin. Working in fume hood with a pair of rubber gloves and eye protecting goggle should be OK.

2. Two Components -- STYCAST 2850 FT is used together with Catalyst 9.

3. Shaking -- STYCAST 2850 FT needs to be shaken or stirred in its own container before doled out. When the can opened, you see everything black, but some additive settling is common during shipping or storage. Catalyst 9 no mixing necessary, it is already homogeneous liquid in its glass bottle.

5. Mix Ratio -- STYCAST 2850 : Catalyst 9 = 100 : 3.5 by weight, 100 : 8.5 by volume. Practically, weight measurement is easier than volume.

6. Blending Two components -- Use a weighing scale to accurately weigh resin and hardener into a clean container. Blend them by hand using a kneading motion for 2-3 minutes. Not too fast mixing speeds, to avoid excessive amounts of air entrapping. Make sure to fasten the tin can lid tightly after use, if not, the resin inside will become easily harder.

7. Application -- Carefully pour the material onto the prepared targets. Make sure to stop pouring in good time.
8. Clean-up -- Right after you finish the task, wash your tools with Acetone if they are not for single use. When the epoxy comes to harden, it is almost impossible to remove it from the body. Use appropriate chemical disposal containers.

9. Curing Time -- Higher temperature will dry and cure faster in general. For example, in 25C it takes 16-24 hours, in 65C it takes 1-2 hours.